Qty:

151

-150 Um:

Each

Date:

Friday, 10/13/2006 9:30:56 AM

User:

Kim Johnston

**Process Sheet** 

**Drawing Name** 

**Part Number** 

Material

**Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: BUSHING

: D2745

: N/A

NIA:

: 11/15/2006

: B

: D2745 REV B

Customer

: CU-DAR001 Daft Helicopters Services

Job Number

: 28974

**Estimate Number** 

: 10503

P.O. Number

: NIA

This Issue Prsht Rev. : 10/13/2006

First Issue **Previous Run** 

: NW

S.O. No. : N)A

: MACHINED PARTS

Written By

Checked & Approved By

Comment

: 27862

: Est C 02.03.07 Update to turn in house NG

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M303R0750

303 Round Bar .75"

Comment: Qty.:

0.1007 f(s)/Unit Total:

303 ROUND .75"

Machine per Folio FA201 Material: AISI 303 SS

Batch: M102318

06/10/31

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn Blank as per Dwg Dests 2745

2-Deburr

INSPECT PARTS AS THEY COME OFF MACH

151

3.0

QC2

QC8

SECOND CHECK

06/11

151

Comment: SECOND CHECK

151

SMALL FAB

SMALL & MEDIUM FAB RESOURCE

S AS THEY COME OFF MACHINE

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & deburr any sharp edges as per dwg

Dart Ae	rospace Ltd							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Yes	s Mg DQ	A: 🗀	<u>)</u> Date: <u> </u>	Xd12/14
				QA:	N/C Close	d:	Date:	
NCR:			WORK ORDER NON-CON	FORMANCE (NO	R)			

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			A	Annroyal			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification A Section C	Approval Chief Eng	Approval QC Inspector			
	•										
•											

NOTE: Date & initial all entries

Date: User: Friday, 10/13/2006 9:30:56 AM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28974

Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description:

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location 575



7.0

QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



## **Dart Aerospace Ltd**

Dait Ac	Tospace								
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									•
Part No	•	PAR #:	Fault Cate	jory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
					QA: N	C Close	d:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR	)			
D.4.T.F.	OTED	Description of NC Section A	Corrective Action Sect			Verific	Verification	Approval	Approval
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
				-					

NOTE: Date & initial all entries

DART AEROSPACE LTD

Description: Bushing

Part Number:

D2745

Inspection Dwg: D2745

Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.010	1061	_			
0.400	+/-0.010	,398				
0.060	+/-0.010	.062	/			
1.020	+/-0.010	1.024	_			
0.030 x 20°	+/-0.010	, 030 X 70°				
Ø0.472	+/-0.010	,472	_			
Ø0.375	+/-0.010	.380		-		
Ø0.560	+/-0.010	.559		!		
Ø0.750	+/-0.010	,749				
		·				
		;*				
		4				
	-					

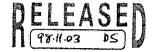
Measured by:	SAS	Audited by: J.F.	Prototype Approval:	N/A
Date:	06/11/01	Date: 06/11/01	Date:	N/A

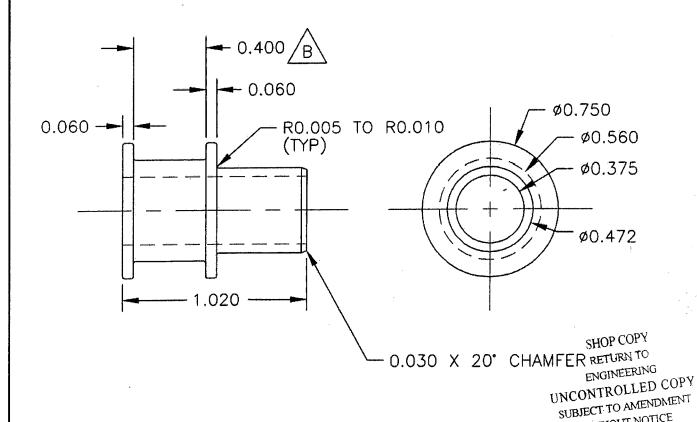
Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue	KJ/RF	. 4



DE	SIGN ##	DRAWN BY	DART AEROSPACE U	
СН	ECKED	APPROYED	DRAWING NO.	REV. B
1	DAF	1 KE	D2745	SHEET 1 OF 1
DAT	Έ		TITLE	SCALE
98	3.10.23		BUSHING	2:1
Α		98.04.16	NEW ISSUE	
В		98.10.23	DIM 0.400 WAS 0.380	

WITHOUT NOTICE





MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RADIUS ALL INSIDE EDGES 0.005 TO 0.010

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES